

Work Order ID 57600

Friday, April 09, 2010 1:32:44 PM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 4/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 10-4-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: B

2-Deburr if necessary

10-4-12

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-4-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

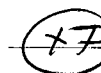


QC

Memo

0.00

S10604/12



Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

7

Cp 10.04.20

Packaging

140

0.00



Large Fab

Memo

0.00

7

Cp 10.04.20

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111679

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

[illegible]

Friday, April 09, 2010 1:32:44 PM

Accept

Setup Start

RESEARCH DESIGN AND METHODS

Stop

Abstract

Cust Item ID:

Start Date: 4/12/2010 **Start Qty:** 6.00

Customer:

Required Date: 4/15/2010 **Req'd Qty:** 6.00

000000

Reference:

Run Start

Abstract

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**

0.00

QC

Memo

0.00

Quality Control

0.00

[illegible]

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location:

0.00

Abstract

Packaging

Memo

0,00

Packaging

W/O:		WORK ORDER CHANGES					
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Page 4

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/21 *AJ*
mf
10-4-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, April 09, 2010 1:32:44 PM

Page 1

Work Order ID: 57600



Parent Item: D3929-041



Parent Item Name: Gusset Assembly


Start Date: 4/12/2010

Required Date: 4/15/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	33.8200	2.8421	3.4		

1810-4-12

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT19

33.82

112663

33.82

112663

D3907-1



Manufactured

No

130

Each

59.0000

12.0000

Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

WA

59

56517

18

57242

41

4

Pl 10.04.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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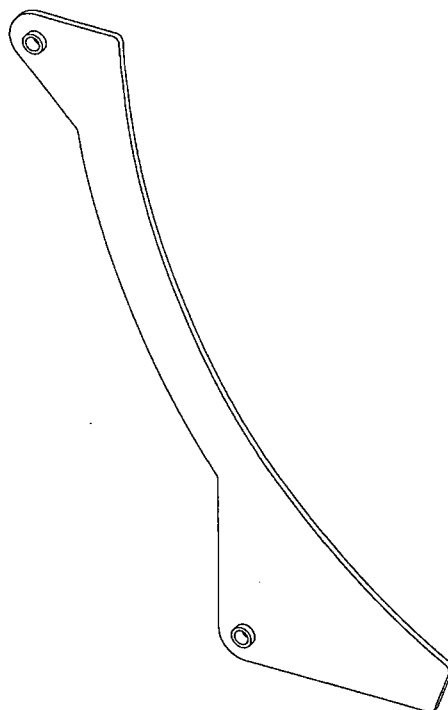
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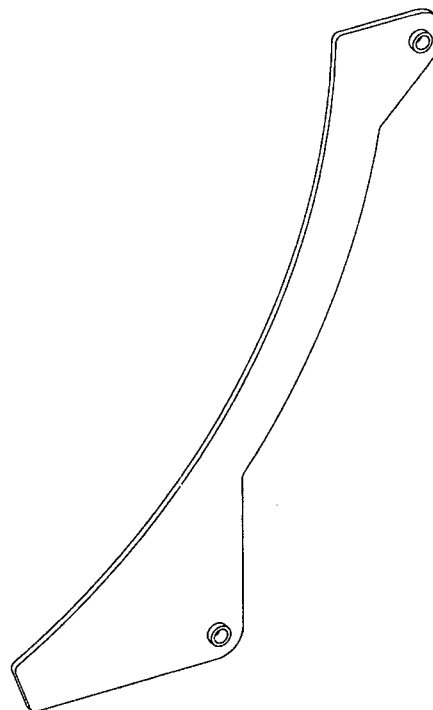
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

#57600

RELEASED
9/10/4/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
		DRAWING NO. D3929		
		REV. A		
		SHEET 1 OF 3		
		TITLE GUSSET ASSEMBLY		
		SCALE NTS		
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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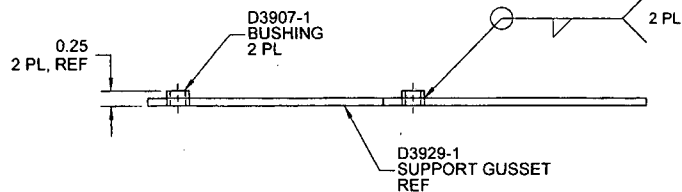
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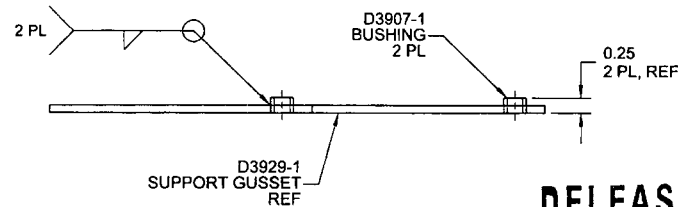
NOTE: Date & initial all entries

D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22 MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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